D/0: Thursday, 5/4/2006 10:46:27 AM

Kim Johnston **Process Sheet** Customer : CU-DAR001 Dart Hellcopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD) Job Number : 26974 -**Estimate Number** : 10533 P.O. Number : NIA : D2573 Part Number S.O. No. : NA : 5/4/2006 This Issue : D2573 REV E **Drawing Number** Prsht Rev. : NC : N/A Project Number : NIA First Issue Type : MACHINED PARTS : E Drawing Revision : NIA : 26562 Previous Run Material : 5/25/2006 **Due Date** Qty: 12 Um: Each Written By Checked & Approved By Comment Additional Product Job Number: Seq. #: Machine Or Operation: Description: 1.0 D6101007 7075-T7351 8.25X7.75X2.5 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: 13.24 070 2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 26974 Double check by: J. L 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. 3.0 MILLING CONV CONVENTIONAL MILLING MACHINE Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

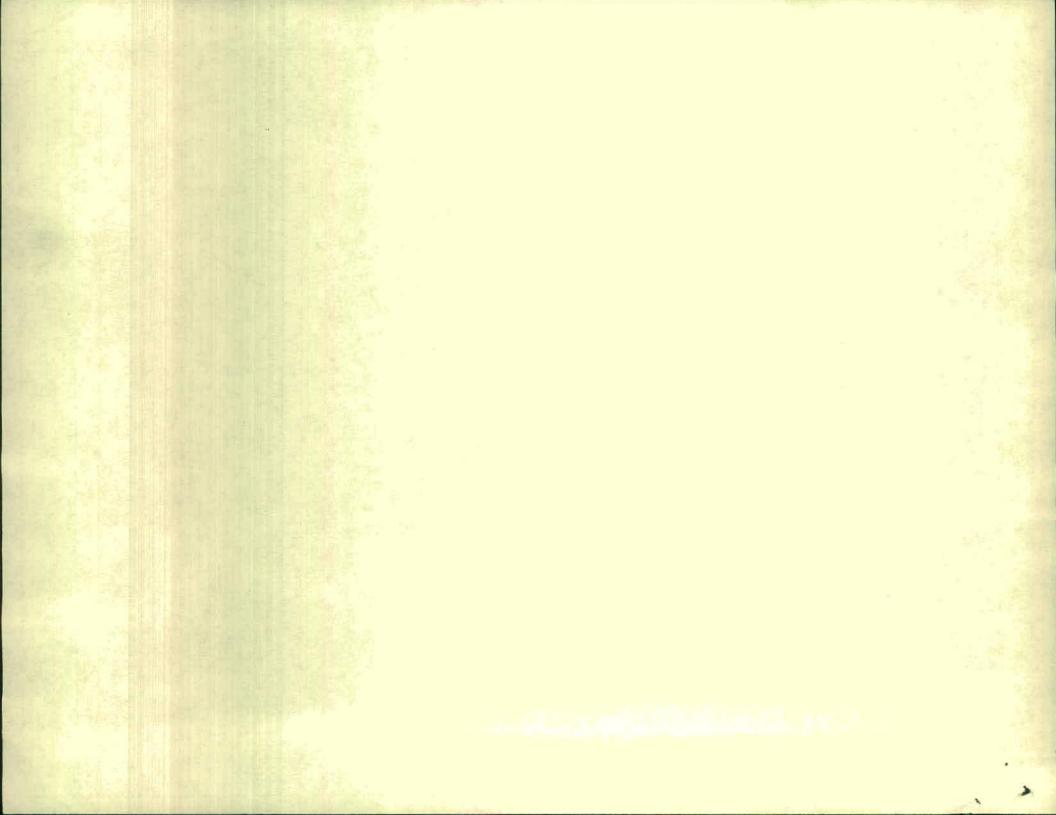
3.30



EP 06/16/13



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Thursday, 5/4/2006 10:46:27 AM Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26974

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description:

30

5.0

6.0

QC8

SECOND CHECK

HAND FINISHING1



Comment: SECOND CHECK

HAND FINISHING RESOURCE #1





Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

POWDER COATING



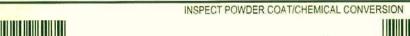
7.0



Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



8.0 QC3





9.0 PACKAGING 1 PACKAGING RESOURCE #

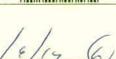


Comment: PACKAGING RESOURCE #1

Identify and Stock Location: _

10.0

DOCUMENT CONTROL

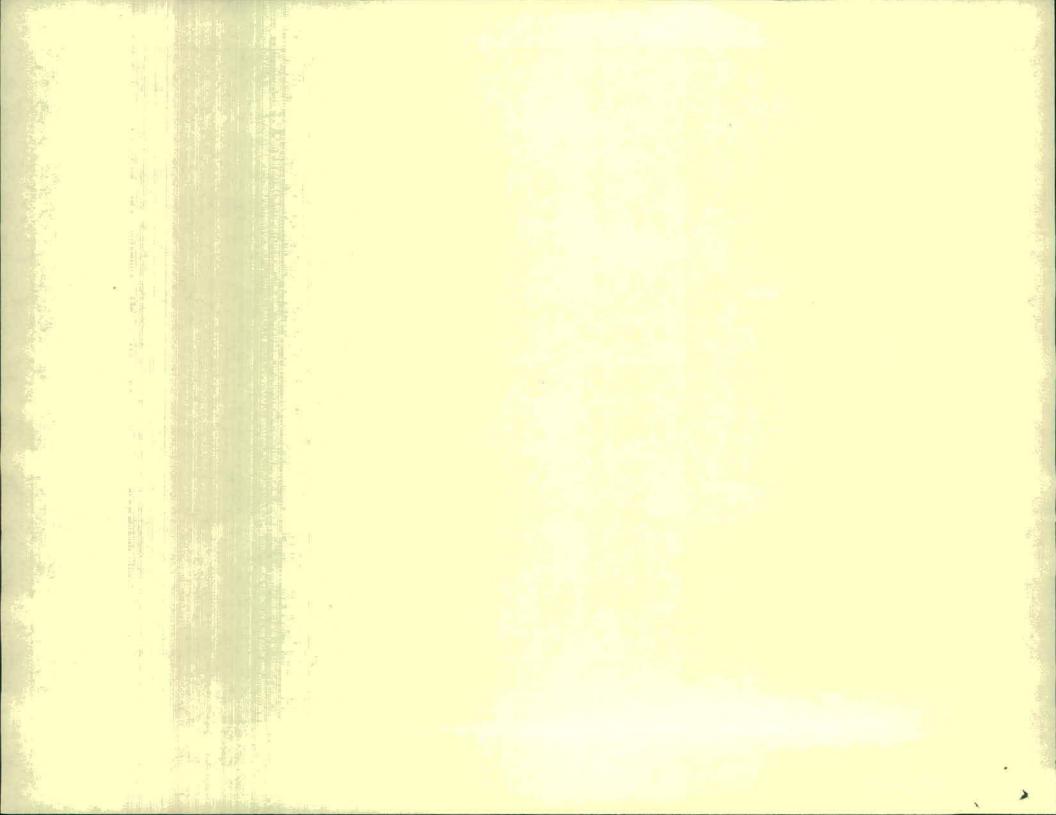


Comment: DOCUMENT

Inspection Level 21

Job Completion





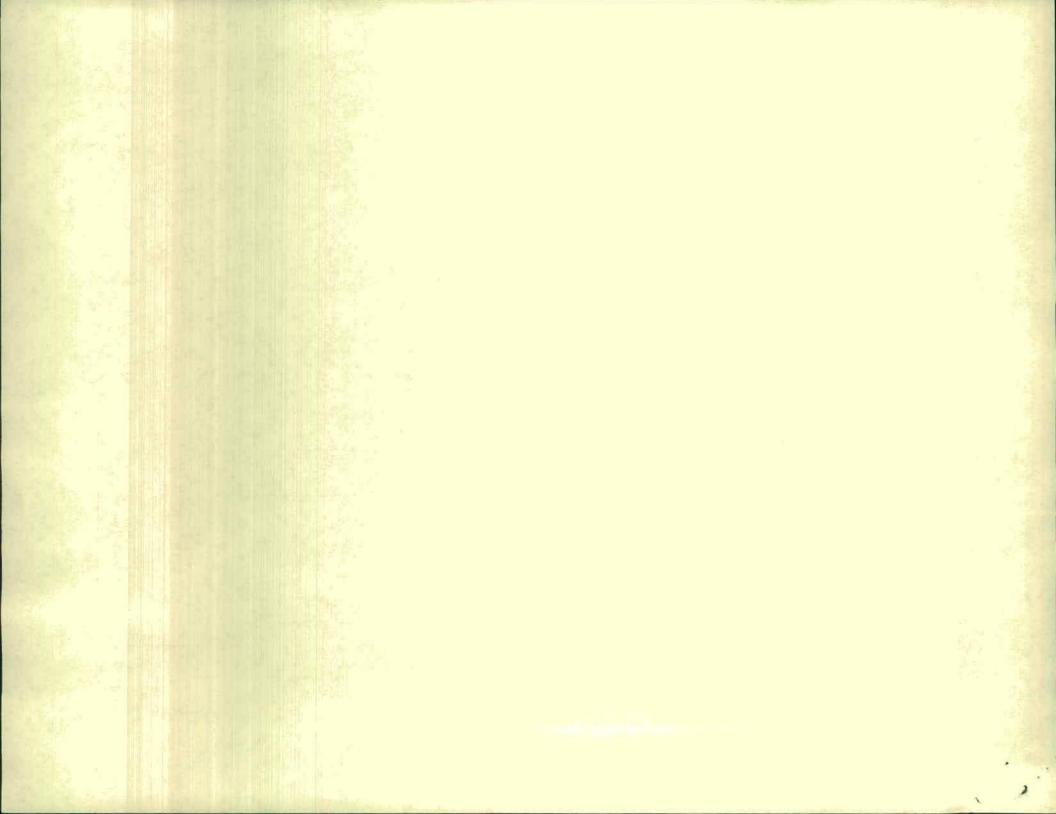
DART AEROSPACE LTD	Work Order:	26974
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682		0.440				
В	1.745	1.755		1.748	1-749	1-150	1.746		
C	3.495	3.505		3.499	3,499	3-501	3 428		
D	1.745	1.755		1.700	1.750	1.750	" 746		
E	7.990	8.010		2.999	8-001	8.003	8.064		
F	0.490	0.510		0.490	0.497	0.498	\$9994		
G	0.257	0.262	DT8683		0.00	0.258	7		
Н	0.375	0.380	DT8684	+	0.376	0 777	1		
1	0.490	0.510		0.	0.499	0. 501	0.498		0.5=400
J	1.174	1.184		1.178	0.566	0.501	1.178		
K	0.558	0.578			0.566	0.568	6566		
L	1.174	1.184		1.178	1-180	1-180	1.178		
M	1.365	1.375			1.371	1-180	1368		
N	2.495	2.505			2.497	2. 447	2.497		
0	4.119	4.129			4.131	4,101	4.126		
Р	0.115	0.135		0	0.124	0.134	0127		
Q	0.115	0.135			0.134	0.134	0.135		
R	0.240	0.260			0-247	0.246	028Z		
S	0.115	0.135		70	0.116 0.188 3.231	0.115	0122		-
Т	0.178	0.198		0088	0.188	0.188	6.188		
U	3.210	3.250		4	3,231	3.232	3.230		
V	0.230	0.250		0.233	0.235	0.234	0.732		
W	0.115	0.135	*;	-	0,118	0.114	0.125		
X	0.308	0.313			0.310	0.310	0-316		
Y	0.760	0.765		~	0.310	0.310	0.765		
Z	0.352	0.372		0.372	0.364	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	6-57x		
AB	0.615	0.635		0.624	0 -625	0.638	0.687		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.243	0-241	0.242	0.240		
AE	1.500	1.520		1.5/3	1.518	1.518	1.515		
AF	0.115	0.135		0.127	0-127	0.126	6-135		
AG	0.240	0.280		0.272	0.270	0.265	0-260		
AH	0.240	0.260		0.245	0.240	0. 241	0-243		
Al	2.000	2.020		2.000	2.005	2.006	3.001		
AJ	0.023	0.043		0.033	0.033	0.033	0-033		
		ept/Rejec	ct	4,433	0.00	0,033	0.033		

Measured by: 5-6-	Audited by
Date: 06/05/25	Date: 06/06/13

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.26	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	. KJ	
D	05.05.05	Added dimension AI	KJ/RF	-1
E	05.12.05	Added dimension AJ	KJ/JLM A	Gul



DART AEROSPACE LTD	Work Order:	26974
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				R	ecorded Act	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	-	_	-		-	
B	1.745	1.755		1.746	4746	1.746			
C	3.495	3.505		3.498	2 49	3.499			
D	1.745	1.755		1.746	3.49	1.746			
E	7.990	8.010		8004	90002	8 000			
F	0.490	0.510		0.495	8002 A.495	0.499			
G	0.257	0.262	DT8683	0-258	-	500			
Н	0.375	0.380	DT8684	0.376	-				
L L	0.490	0.510		and the or	196 0.496	0-496			
J	1.174	1.184		1:175	1.175	1:175			
K	0.558	0.578		0.563	6.563	0563			
L	1.174	1.184		1.175	1.175	1:175			
M	1.365	1.375		1.369	1.370	1:371			
N	2.495	2.505		2.498	2.499	2,498			
0	4.119	4.129		4.121	4.121	4,971		107	
P	0.115	0.135		0.17.7	0.125	91721			
Q	0.115	0.135		6.135	6.135	6-135			
R	0.240	0,260		0.251	6.750	8 249			
S	0.115	0.135		0115	6.115	0116			
Т	0.178	0.198		891.0	6 188	0.188			
U	3.210	3.250		3:230	3.230	3 - 236			
V	0.230	0.250		0-232	6-235	6.235			
W	0.115	0.135		6.124	0.124	6,24			
X	0.308	0.313		0-310	0.316	6.3/6			
Υ	0.760	0.765		0.765	0.316	0.765			
Z	0.352	0.372		0365	6.360	6.360			
AA	0.470	0.530		0.500	6 500	CO 506			
AB	0.615	0.635		0676	0.625	0.629			
AC	0.053	0.073		0.063	0-463	0.663			
AD	0.240	0.260		6.246	0240	6.246			=======================================
AE	1.500	1.520		1-512	1.514	15/4			
AF	0.115	0.135		6.135	01/35	6.135			
AG	0.240	0.280		0.260	0.260	0.200			
AH	0.240	0.260		6.247		0.244			
AI	2.000	2.020		2.002	2.004	7.002			
AJ	0.023	0.043		0 .033	0.030	0030			
-	Acc	ept/Rejec	t		120.50	0.50			

Measured by:	Er	Audited by Sc- at-126.13
Date:	. 06/06/13	Date:

Date	Change	Revised by	Approved
	New Issue		Approved
02.09.26	Re-format; Added Rev. D		
02.10.11			
05.05.05			1
05.12.05	Added dimension AJ		Gull
	02.09.26 02.10.11 05.05.05	New Issue 02.09.26 Re-format; Added Rev. D 02.10.11 Re-format; Added DT8682, DT8683, DT8684 05.05.05 Added dimension AI	New Issue

